

Date: Friday, 01/08/2008 10:42:32 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: GUSSET
<b>Job Number</b>	: 40893C		
<b>Estimate Number</b>	: 10843		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D22495
<b>This Issue</b>	: 01/08/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2249 REV. E
<b>First Issue</b>	: //	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 40486C	<b>Drawing Revision</b>	: E
	<b>Type</b> : SMALL /MED FAB	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 10/08/2008
<b>Checked &amp; Approved By</b>	: <u>JUL 08.8.05</u>	<b>Qty:</b>	20
<b>Comment</b>	: Est: D 05.02.04 Added Step 9 KJ/RF	<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S16GA	304/316 Sheet .063
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**Comment:** Qty.: 0.0243 sf(s)/Unit Total: 0.4860 sf(s)  
 304/316 .063 Sheet  
 Material: AISI 304/316 SS 0.063" thick  
 (M304S16GA) Batch: M108724

EP 08/10/15 (23)

2.0	SHEAR	SHEAR
-----	-------	-------



**Comment:** SHEAR  
 Cut blank: 1.000" x 1.600"

EP 08/10/15 (23)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Deburr any rough edges

EP 08/10/15 (23)

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



**Comment:** INSPECT WORK TO CURRENT STEP

S 08/10/15 (23)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: \_\_\_\_\_

EP 08/10/16 CARL

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 01/08/2008 10:42:32 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUSSET

Job Number: 40893C

Part Number: D22495

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/17 *JA*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*mf 08-10-17*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

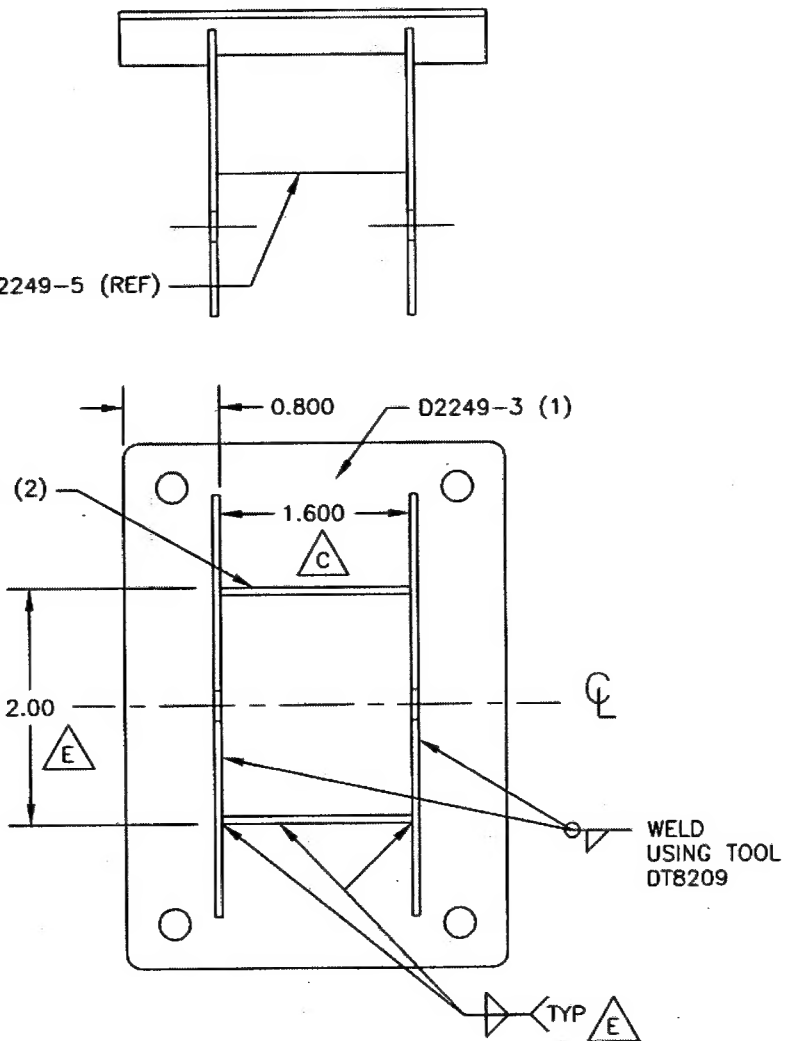
NOTE: Date & initial all entries

**DART**



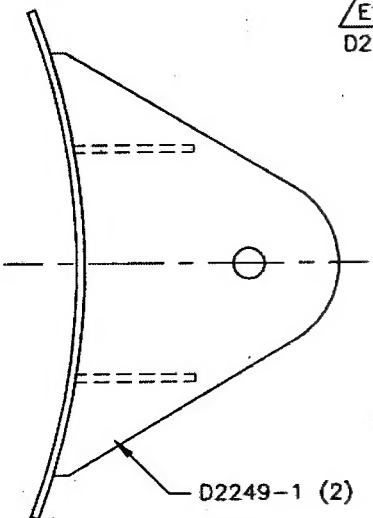
**RELEASED**  
99.10.12 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
HE	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED RF	DRAWING NO. D2249
DATE 99.09.20	TITLE FITTING	REV. E SHEET 1 OF 4
A	94.06.20	NEW ISSUE
B	95.11.30	DIMENSION CHANGE
C	95.12.14	DIMENSION CHANGE
D	98.04.30	Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS
E	99.09.20	ADDED GUSSET



D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK  
WELD PER DART QSI 004  
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED



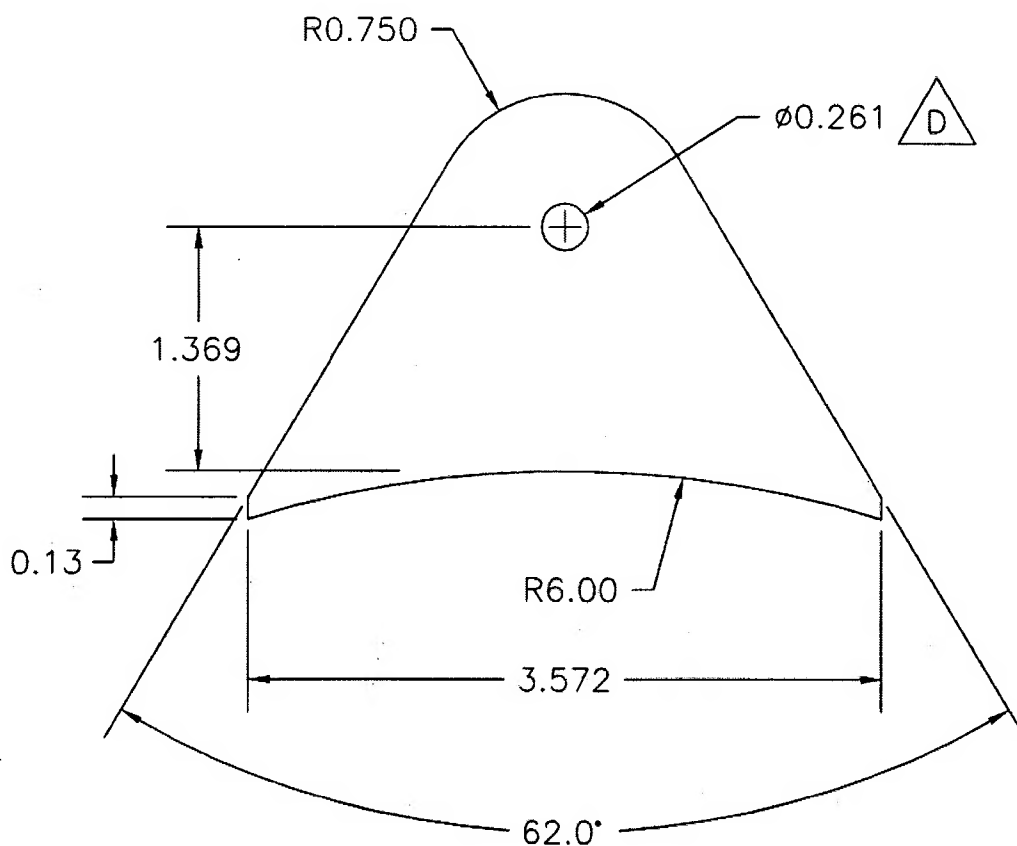
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WITHOUT NOTICE

WORK ORDER  
NO 40883



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20	TITLE FITTING		SCALE 1:1

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99.10.12 KE



D2249-1 LUG

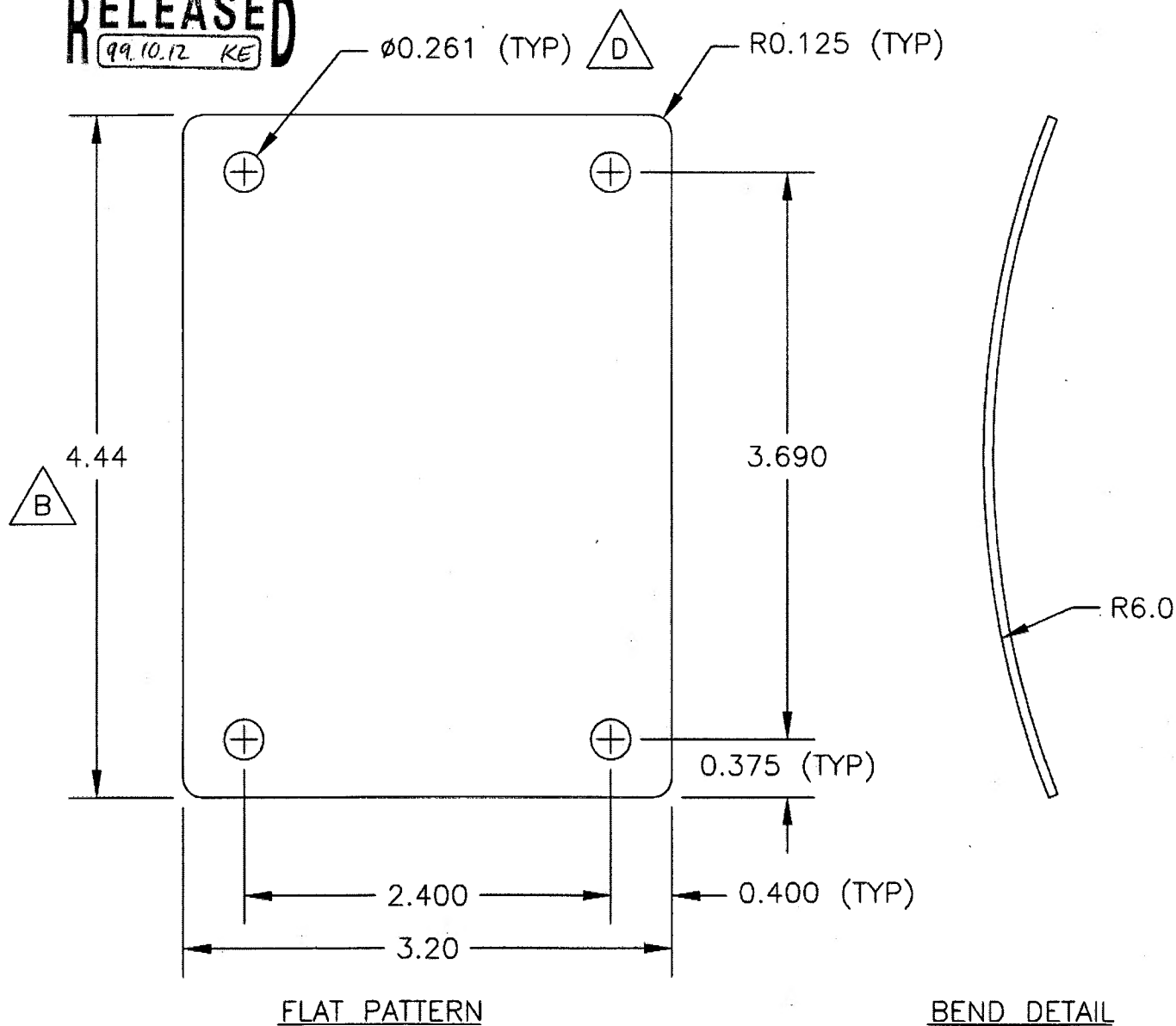
MATERIAL: AISI 304/316 SS 0.063 THICK  
ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
NO. *40893C*



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DATE 99.09.20	TITLE FITTING	SCALE 1:1	

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99.10.12 KE



D2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

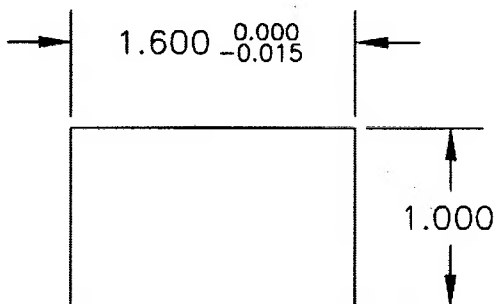
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
No. 40893



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED  
19.10.12 KE



D2249-5 GUSSET

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WITHOUT NOTICE  
WORK ORDER  
NO. 40893

MATERIAL: AISI 304/316 SS 0.063 THICK  
ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED